

Work Order ID 62296

Friday, September 24, 2010 3:08:52 PM



Page 1

Item ID: D4106-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer, Sill Doulber

Start Date: 9/27/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-9-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4106	A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: 1

KYDEX STEEL GREY

2-Deburr if necessary

B10-9-27



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-9-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

S 10/09/22



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 127

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/29
10-9-25
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, September 24, 2010 3:08:52 PM

Page 1

Work Order ID: 62296

Parent Item: D4106-5

Parent Item Name: Spacer, Sill Doulber

Start Date: 9/27/2010

Required Date: 10/4/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	394.8600	0.2109	0.666	1.3		



Kydex steel grey



1810-9-27

Location

Loc Qty

Loc Code

therm

394.86

111807

394.86

111867

5

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DART AEROSPACE LTD	Work Order:	62296
Description: SPACER Sill Doubler	Part Number:	D4106-5
Inspection Dwg: D4106-5 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

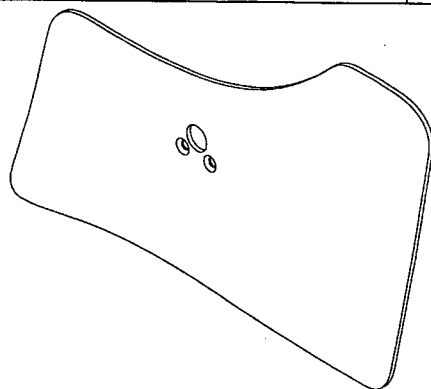
First Article

Prototype

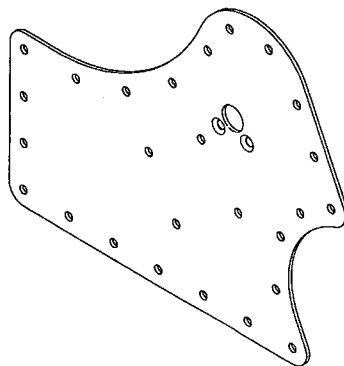
[illegible]

Measured by:	13	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-27	Date:	10/09/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

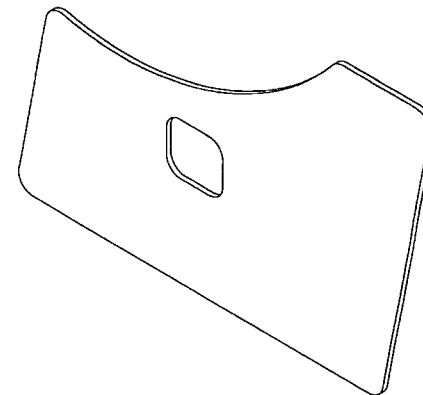


D4106-1 SILL DOUBLER, LH

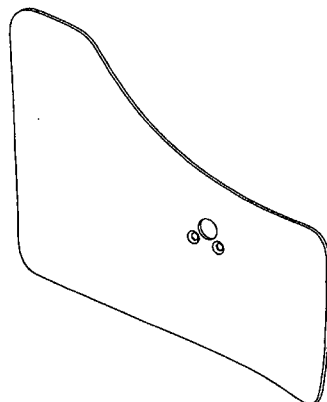


D4106-3 CREW DOOR DOUBLER, LH

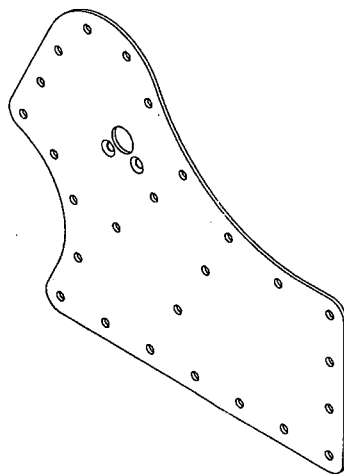
#62296



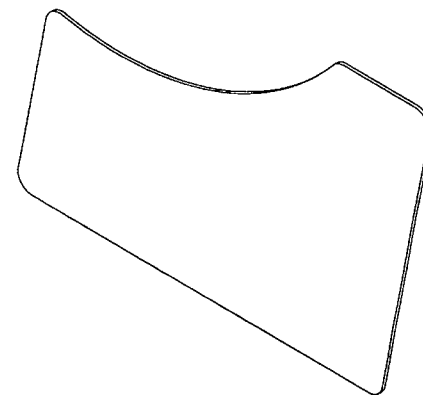
D4106-5 SPACER, SILL DOUBLER



D4106-2 SILL DOUBLER, RH



D4106-4 CREW DOOR DOUBLER, RH



D4106-7 TEMPLATE

RELEASED
2010-09-23
JPH

A NEW ISSUE		JPH	10.07.15
REV.	DESCRIPTION		BY DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4106	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLERS	NTS
DATE	10.07.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

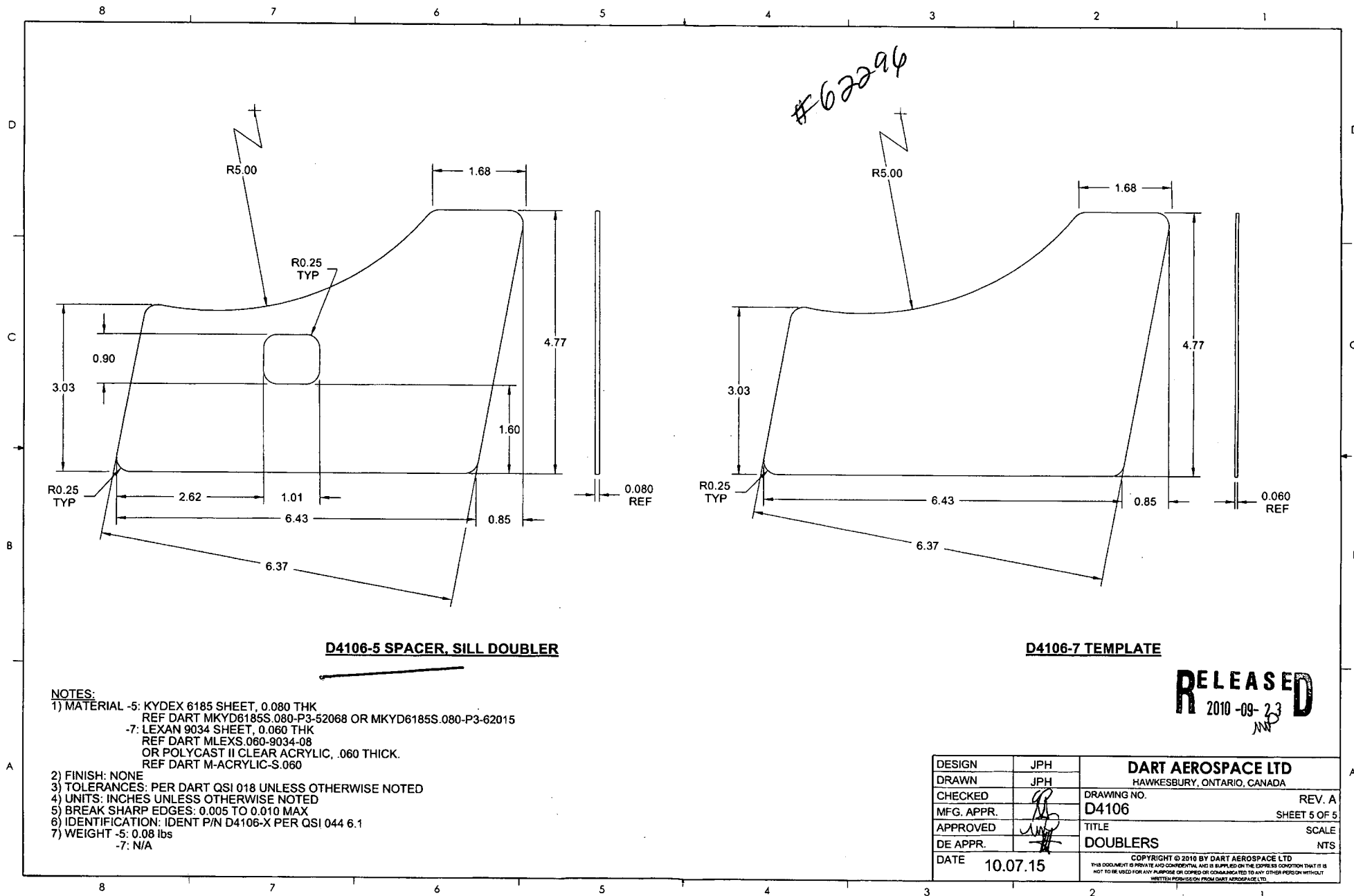
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